




Small Damage Repairs		
1		<p>Pre-Cleaning Pre-wash/clean vehicle prior to disassembly (power wash undercarriage area at repair).</p>
2		<p>Initial Prep Sand DA sand the repair area using grade 80, removing paint beyond damage by 2–4 in. Blow off with clean, dry air and re-clean with surface cleaner.</p>
3		<p>Mix and Apply Filler Mix and apply filler per manufacturer's recommendation or use the 3M™ Dynamic Mixing System. Keep the body filler within the primer featheredge area. Cure the body filler 15–20 minutes at 75°F.</p>
4		<p>Sand Filler Using a hand block, shape sand the body filler with P80 abrasive. Apply dry guide coat and finish block sanding with P150 abrasive. DA featheredge the repair area with P180 abrasive disc. Inspect the repair for quality, if glaze is not required, continue to step seven.</p>
5		<p>Mix and Apply Glaze Blow off the repair area completely removing sanding dust from the surface. Mix and apply glaze if required per manufacturer's recommendation or if using the 3M™ Dynamic Mixing System. Keep the glaze within the primer featheredge area. Cure glaze for 15–20 minutes at 75°F.</p>
6		<p>Sand Glaze Sand polyester glaze with P180. Use 3M™ Dry Guide Coat between sanding steps to highlight imperfections.</p>
7		<p>Final Sand and Inspect Blow off repair area. Featheredge the surrounding area using P180 abrasive. Inspect the repair for quality.</p>
<p>Visit www.3MCollision.com for more SOPs and videos</p>		

Product List	
<p>3M™ Car Wash Soap Concentrate, 1 gallon, PN 38377</p>	
<p>3M™ All Purpose Cleaner and Degreaser Concentrate, 1 gallon, PN 38350</p>	
<p>3M™ Cubitron™ II Clean Sanding Hookit™ Abrasive Disc, 3 in., 80+ grade, PN 31361; 6 in., 80+ grade, PN 31371</p>	
<p>3M™ Platinum™ Plus Body Filler, 1 gallon, PN 01131; for DMS, PN 05863</p>	
<p>3M™ Dry Guide Coat, 50 gram applicator kit, PN 05861</p>	
<p>3M™ Platinum™ Plus Finishing Glaze, 30 oz., PN 31180</p>	
<p>3M™ Platinum Glaze for DMS, PN 05862</p>	
<p>3M™ Cubitron™ II Hookit™ Clean Sanding Sheet Roll, 70mm x 12m, 80+ grade, PN 34442; 150+ grade, PN 34445; 180+ grade, PN 34446</p>	
<p>3M™ Cubitron™ II Clean Sanding Hookit™ Disc, 6 in., 180+ grade, PN 31374</p>	

Think About Your Health	
<p>3M™ E-A-R™ Skull Screws™ Ear Plug, PN P1300</p>	
<p>3M™ Half Facepiece Respirator, PN 07182</p>	
<p>3M™ Lexa™ Protective Eyewear, PN 15200</p>	

Protect Your Repairs

Corrosion protection is recommended for this type of repair.

Protect repairs with a self-healing, non-hardening formula

- 3M Cavity Wax Plus, PN 08852
- 3M™ Cavity Wax Plus Applicator Wand Kit, PN 08851



All OEMs recommend the application of internal anti-corrosion material during body repair, which includes cavity wax.

Individual Product Instruction and Safety Information

For individual product instructions and applicable precautions see product labels and associated literature for the individual product at www.3MCollision.com

For product material safety data sheets see go.3M.com/SDS

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IMPORTANT NOTE: There are of course many factors and variables that can affect an individual repair, so the technician and repair facility need to evaluate each specific application and repair process, including relevant vehicle, part and OEM guidelines, and determine what is appropriate for that repair.



3M Automotive Aftermarket Division
3M Center, Building 223-6N-01
St. Paul, MN 55144-1000
U.S.A.

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